

Work Order ID 111281

111281

Page 1

Thursday, January 09, 2014 3:24:13 PM

Item ID: D350-636-015

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube LH Run-On Landing Wearplates Aerazur / Apical Cylindrical Float Compatible

Start Date: 1/9/2014 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 1/13/2014 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: Date: 14-01-9 Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4168-041	B

100 0.00

100

DOCUMENT CONTROL

DC Memo record fwd angle: 89.3° DP 14-1-15 0.00

Photocopy blue file and type labels per PPP D350-636-015 CHG 005

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Required Date: 1/13/2014 Req'd Qty: 1.00 ***1***

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

110

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D4168 *Ensure Squareness of end*

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr, section H-H

5- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting, section H-H

7- Drill fwd step holes using DT9616. Ensure proper positioning. All holes as per dwg D4168, detail A

6- Drill pilot holes as per Dwg D4168 sheet 4 (D4168-1 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)

4- Clecko DT8863B on second side of tube and drill pilot holes for detail B. *****SECOND SIDE*****

6- Drill most FWD wearplate hole using DT9678 locating off of 66.54" hole.

8- Open up holes of Detail A to 0.297" (total of 2 holes per side) and .201" (total of 1 hole per side) open holes of detail D section H-H to 0.500" as per dwg D4168

9- Weld D2744 Cap as per Dwg D4168 and QSI 004. Fill grooves in bend left from bending as per QSI 004

14-01-15 DBL

mm 14/01/15

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Item Name: Skidtube LH Run-On Landing Wearplates Aerazur / Apical Cylindrical Float Compatible

Start Date: 1/9/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/13/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

A/R Aluminum Rod batch: M127069 BE14/01/14
11-Grind welds flush as per Dwg D4168

120

QC10- Inspect visual per QSI004- ground welds 0.00

120

QC

Memo

0.00

Quality Control

① 14-01-16 DAS
9
9-89

130

QC5- Inspect part completeness to step on W/O 0.00

130

QC

Memo

0.00

Quality Control

① 14-01-16 DAS
9
9-89

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Start Date: 1/9/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/13/2014 Req'd Qty: 1.00

1

Customer:

Reference:


Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.00							
Quality Control									



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Start Date: 1/9/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/13/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00

160

Skidtubes

0.00

Skidtubes

Memo

1-Open up holes of Detail C and ground handling section AL-AL to 0.625"
(total of 8 holes per side)
as per dwg D4168.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D4168.

3- Open float hole to 0.500" (4 per side) section AJ-AJ

Open wearplate holes to size as per dwg (4 holes per sides) , section CG-CG

4-Chamfer holes of Detail B, C, ground handling section AL-AL and float holes
section AJ-AJ per dwg D4168 (welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015
A/R Sikaflex-291 batch: 127094

exp. date: 14/8/1614-01-16 DGL

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D4168 and D4170-1
& QSI004

(welding instructions on sheet 8)

A/R Aluminum Rod batch: M127069

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

BE14-01-20

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Setup Start ***NS1***

Revision ID:

Item Name: Skidtube LH Run-On Landing Wearplates Aerazur / Apical Cylindrical Float Compatible

Stop ***NS2***

Start Date: 1/9/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/13/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	✓ 10-Grind welds flush as per Dwg D4168								
	✓ 11-Spot face ground handling holes section (total of 4 places per side) as per dwg D4168, section AL-AL								
	12- C'bore section CG-CG. ADJUST TOOLING AS REQUIRED. VERF BY: <u>DC</u>								
	13- Deburr holes								
	***** FOR DELUXE SKIDTUBE IF APPLICABLE DRILL TOW RING HOLE IN TUBE ***** <u>Ref wo B 106955</u>								
170	QC10- Inspect visual per QSI004- ground welds	0.00							
170									
QC	Memo	0.00							
Quality Control									

14-1-20 DC

DP 14-1-21

① 14-01-21

DAS
9
9-89

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Start Date: 1/9/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/13/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo ***VERIFY C'BOARD IS GOOD***	0.00 0.00							DAS 9 9-89
190 *190* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.	0.00 0.00							1 746 14-1-22
200 *200* SprayPaint Spray Painting	 Memo 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: <u>120543</u> 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: <u>128009</u>	0.00 0.00							1 0 0 12 14-1-26

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 Start Date: 1/9/2014 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/13/2014 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC14- Inspect Spray Paint	0.00							
210									
QC	Memo	0.00							
Quality Control	Inspect for foreign object per QSI 024								
230	HandFinishing	0.00							
230									
HandFinish	Memo	0.00							
Hand Finishing	1- Install inserts as per Dwg D4168								
	2-Inspect for Foreign Objects								
	3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D4168								
	SIKA FLEX 241								
	BATCH: <u>14127093</u>								
	EXP DATE: <u>14102</u>								
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube								
	A/R 55-o'ring lube batch: <u>14121621</u>								
	5-Coat all exposed fasteners with "LPS Procyon" batch: <u>14122900</u>								

1412 141011 29

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NS1

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Stop

NS2

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Start Date: 1/9/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/13/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC5- Inspect part completeness to step on W/O	0.00							
240									
QC	Memo	0.00				1			
Quality Control									
250	Pick Kit	0.00							
250									
Packaging	Memo	0.00				1			
Packaging	If making a D350-636-215 pick kit will only requires: 1 X AN3C37A 1 X AN3C34A 1 X AN3C42A 2 X D3493-1								
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.00				1			
Quality Control	*****ensure antiseize is on AN8C21A bolts*****								

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Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube LH Run-On Landing Wearplates Aerazur / Apical Cylindrical Float Compatible

Start Date: 1/9/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/13/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

270

0.00

270

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPPD350-636-015

Location:

PPP rev:

PPP 106955

142-4

DAS
6
9-89DAS
6
9-89

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.00

Quality Control

MLJ 14-02-05

MLJ 14-02-05

Picklist Print

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Work Order ID: 111281

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Parent Item: D350-636-015

D350-636-015

Parent Item Name: Skidtube LH Run-On Landing Wearplates Aerazur / Apical Cylindrical Float Compatible

Start Date: 1/9/2014

Required Date: 1/13/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.09.28 new issue DD verf:EC IPP Rev:B
11.04.14 ecn11-553 DD verf:EC IPP Rev:C 11.10.18 as per
NCR 11-906 DD verf:EC IPP Rev:D 112.04.16 AS PER ECN 12-
542 DD verf:EC IPP REV:E 13.08.28 PER ECN13-594 DD
VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C34A *AN3C34A* BOLT		Purchased	No			230	Each	50.0000	1	1		DAS 33 9-89	9
				<u>Location</u>				<u>Loc Qty</u>					
				ST352				50					
				m127044				50					
AN3C36A *AN3C36A* Bolt		Purchased	No			230	Each	213.0000	4	4		127044 14-01-31	
				<u>Location</u>				<u>Loc Qty</u>					
				FG				25					
				101261				4					
				122204				11					
				124827				10					
				ST354				38					
				m127578				38					
				ST514				150					
				m127769				100					
				m127770				50					
D3492-1 *D3492-1* Plug		Manufactured	No			230	Each	195.0000	8	8		14-01-18	
				<u>Location</u>				<u>Loc Qty</u>					
				FP001				195					
				104844				195					

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Work Order ID: 111281

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Parent Item: D350-636-015

D350-636-015

Parent Item Name: Skidtube LH Run-On Landing Wearplates Aerazur / Apical Cylindrical Float Compatible

Start Date: 1/9/2014

Required Date: 1/13/2014

D3492-3

Manufactured No

230

Each

Start Qty: 1.00
277.0000 8 8

Required Qty: 1.00

D3492-3

Plug

**

92 10/01/21

Location

Loc Qty

Loc Code

FP001

277

104853

72

107331

105

109800

100

✓ 8

D3873-1

Manufactured No

230

Each

406.0000 7 7

D3873-1

Bushing

**

92 10/01/28

Location

Loc Qty

Loc Code

ST067

406

104858

84

105611

301

109110

21

✓ 7

D4154-041

Manufactured No

230

Each

4.0000 1 1

D4154-041

Wearplate Assembly

**

92 10/01/28

Location

Loc Qty

Loc Code

FP002

4

106716

4

✓ 1

D4170-1

Manufactured No

230

Each

159.0000 4 4

D4170-1

Bushing

**

92 10/01/20

Location

Loc Qty

Loc Code

LG001

159

107681

34

107896

125

4

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Shop Packet Print

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D350-636-015

Parent Item Name: Skidtube LH Run-On Landing Wearplates Aerazur / Apical Cylindrical Float Compatible

Start Date: 1/9/2014

Required Date: 1/13/2014

D4171-1 Manufactured No

230

Each

33.0000

Start Qty: 1.00

Required Qty: 1.00

1 1

D4171-1

Bushing

**

ll 14/01/25

Location

Loc Qty

Loc Code

ST098

33

109144

22

99276

11

MS21043-3

Purchased No

230

Each

899.0000

5

MS21043-3

Nut

**

ll 14/01/28

Location

Loc Qty

Loc Code

FG

80

103691

80

GA

4

m126741

4

ST315

815

124555

92

m126741

723

NAS1149C0363R

Purchased No

230

Each

1,043.000

9

NAS1149C0363R

Washer

**

ll 14/01/28

Location

Loc Qty

Loc Code

FP001

704

114742

704

ST292

339

122441

339

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Parent Item Name: Skidtube LH Run-On Landing Wearplates Aerazur / Apical Cylindrical Float Compatible

Start Date: 1/9/2014

Required Date: 1/13/2014

NAS1515H3L

Purchased

No

230

Each

Start Qty: 1.00
454.0000 4 4

Required Qty: 1.00

***NAS1515H3I ***

Washer

**

ll 14/01/26

Location

Loc Qty

Loc Code

FG

40

102472

40

ST297

414

124542

14

m127831

400

x J

NAS1611-010

Purchased

No

230

Each

195.0000 8 8

NAS1611-010

O-RING

**

ll 14/01/28

Location

Loc Qty

Loc Code

FP001

195

m126988

45

m127813

150

x 2

x 6

NAS1611-013

Purchased

No

230

Each

166.0000 8 8

NAS1611-013

O-RING

**

ll 14/01/28

Location

Loc Qty

Loc Code

FP001

166

125445

16

m127813

150

x 8

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Start Date: 1/9/2014

Required Date: 1/13/2014

AN3C37A

Purchased

No

250

Each

127.0000

Start Qty: 1.00

Required Qty: 1.00

AN3C37A
BOLT

**

DAS
33
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST324

4

M121068

4

ST353

123

M126345

48

M127823

75

126345

AN3C42A

Purchased

No

250

Each

32.0000

AN3C42A
Bolt

**

DAS
33
9-89

14-01-31

DAS
31
9-89

Location

Loc Qty

Loc Code

FG

5

121103

5

ST353

27

m126293

2

m127300

25

126293

NAS1149D0863J

Purchased

No

250

Each

991.0000

NAS1149D0863.J

Washer

**

22 141012v

Location

Loc Qty

Loc Code

FP001

6

118078

6

ST293

185

125484

185

ST510a

800

125268

600

125635

200

✓2

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Parent Item Name: Skidtube LH Run-On Landing Wearplates Aerazur / Apical Cylindrical Float Compatible

Start Date: 1/9/2014

Required Date: 1/13/2014

D2744 Manufactured No 110 Each 49.0000 Start Qty: 1.00 Required Qty: 1.00

D2744

Cap

**

BE 14/01/14

Location

Loc Qty

Loc Code

LG001

49

100398

28

87543

21

D2600-3-BENT

Manufactured No

110 Each

3.0000

1

1

D2600-3-BFNT

Extrusion Bent

**

Location

Loc Qty

Loc Code

LG002

3

116840

3

109789

D2743

Manufactured No

160 Each

299.0000

8

8

D2743

Crossbolt Spacer

**

14-01-15 DGL

BE 14-01-16

Location

Loc Qty

Loc Code

LG001

299

106245

9

107359

36

107907

122

109799

132

D2739

Manufactured No

160 Each

5.0000

1

1

D2739

350 I Beam

**

Location

Loc Qty

Loc Code

LG002

5

109973

5

14-01-16 DGL

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D350-636-015Parent Item Name: Skidtube LH Run-On Landing Wearplates Aerazur / Apical Cylindrical Float
Compatible

Start Date: 1/9/2014

Required Date: 1/13/2014

D3490-3

Manufactured No

160

Each

Start Qty: 1.00
144.0000 4 4

Required Qty: 1.00

D3490-3

Cross Bolt Spacer

**

BE 14/01/20

LocationLoc QtyLoc Code

LG001

144

103883

1

107913

63

109933

80

4

D3490-1

Manufactured No

160

Each

209.0000 4 4

D3490-1

Cross Bolt Spacer

**

BE 14/01/20

LocationLoc QtyLoc Code

LG001

209

107419

41

109932

168

4

ALS4-1032-225

Purchased No

230

Each

380.0000 4 4

ALS4-1032-225

Rivnut

**

10/01/20

LocationLoc QtyLoc Code

FG

30

M127028

30

ST280

10

M127028

10

st555

340

M127092

340

XJ

Picklist Print

Thursday, January 09, 2014 3:25:22 PM

Page 8

Work Order ID: 111281

111281

Parent Item: D350-636-015

D350-636-015

Parent Item Name: Skidtube LH Run-On Landing Wearplates Aerazur / Apical Cylindrical Float Compatible

Start Date: 1/9/2014

Required Date: 1/13/2014

AN8C35A

Purchased

No

230

Each

125.0000

Start Qty: 1.00

1

1

Required Qty: 1.00

AN8C35A

Bolt

**

ll 1/10/26

Location

Loc Qty

Loc Code

FG

4

121275

4

FP001

121

m126293

47

m127061

24

m127823

50

D3488-041

Manufactured

No

230

Each

16.0000

1

1

D3488-041

Blade Fitting LH

**

ll 1/10/26

Location

Loc Qty

Loc Code

FP001

16

103877

4

107196

12

AN6C44A

Purchased

No

230

Each

56.0000

4

4

AN6C44A

Bolt

**

ll 1/10/26

Location

Loc Qty

Loc Code

FG

2

103964

2

ST340

50

123900

50

ST341

4

m127300

4

11127900

Thursday, January 09, 2014 3:25:22 PM

Shop Packet Print

Page 8

Picklist Print

Thursday, January 09, 2014 3:25:22 PM

Page 9

Work Order ID: 111281

111281

Parent Item: D350-636-015

D350-636-015

Parent Item Name: Skidtube LH Run-On Landing Wearplates Aerazur / Apical Cylindrical Float Compatible

Start Date: 1/9/2014

Required Date: 1/13/2014

MS21083C8

Purchased

No

230

Each

85.0000

Start Qty: 1.00

Required Qty: 1.00

1

1

MS21083C8

Nut

**

ll 1/10/25

Location

Loc Qty

Loc Code

ST319

85

m127255

35

m127813

50

xl

D3631-1

Manufactured

No

230

Each

112.0000

8

8

D3631-1

Washer

**

ll 1/10/25

Location

Loc Qty

Loc Code

FP001

112

107324

12

110258

100

xq

NAS1149C0332R

Purchased

No

230

Each

11,566.00

4

4

NAS1149C0332R

WASHER

**

ll 1/10/25

Location

Loc Qty

Loc Code

GA

1233

125654

1233

st510

10333

m126319

2433

m127306

2500

m127410

3000

m127831

2400

xl

Picklist Print

Thursday, January 09, 2014 3:25:22 PM

Page 10

Work Order ID: 111281

111281

Parent Item: D350-636-015

D350-636-015

Parent Item Name: Skidtube LH Run-On Landing Wearplates Aerazur / Apical Cylindrical Float Compatible

Start Date: 1/9/2014

Required Date: 1/13/2014

D2745 Manufactured No

230 Each

Start Qty: 1.00
229.0000 8

Required Qty: 1.00
8

D2745
Bushings

**

Handwritten: 1/16/28

Location

Loc Qty

Loc Code

ST017

229

106847

5

107336

124

110526

100

Handwritten: y 8

NAS1149C0832R

Purchased No

230 Each

359.0000 1

1

NAS1149C0832R
Washer

**

Handwritten: 1/16/28

Location

Loc Qty

Loc Code

ST292

359

122441

92

m114915

117

m125807

150

Handwritten: X1

AN3C6A

Purchased No

230 Each

535.0000 4

4

AN3C6A
Bolt

**

Handwritten: 1/16/28

Location

Loc Qty

Loc Code

FG

10

122416

10

ST513

525

m125709

525

Handwritten: X1

Picklist Print

Thursday, January 09, 2014 3:25:22 PM

Page 11

Work Order ID: 111281

111281

Parent Item: D350-636-015

D350-636-015

Parent Item Name: Skidtube LH Run-On Landing Wearplates Aerazur / Apical Cylindrical Float Compatible

Start Date: 1/9/2014

Required Date: 1/13/2014

MS21043-6

Purchased

No

230

Each

518.0000

Start Qty: 1.00

Required Qty: 1.00

MS21043-6

NUT

**

11/01/25

Location

Loc Qty

Loc Code

FG

20

103693

20

ST315

248

m127255

248

ST509

250

m127813

250

D3493-1

Manufactured

No

250

Each

245.0000

**

DA
33
9-89

14-01-31

D3493-1

Washer

Location

Loc Qty

Loc Code

FG

10

97201

10

ST051

235

105613

16

107916

60

109105

159

MS21083C8

Purchased

No

250

Each

85.0000

**

11/01/25

MS21083C8

Nut

Location

Loc Qty

Loc Code

ST319

85

m127255

35

m127813

50

Thursday, January 09, 2014 3:25:22 PM

Shop Packet Print

Page 11

Picklist Print

Page 12

Thursday, January 09, 2014 3:25:22 PM

Work Order ID: 111281

111281

Parent Item: D350-636-015

D350-636-015

Parent Item Name: Skidtube LH Run-On Landing Wearplates Aerazur / Apical Cylindrical Float
Compatible

Start Date: 1/9/2014

Required Date: 1/13/2014

AN8C21A

Purchased

No

250

Each

95.0000

Start Qty: 1.00

2

2

Required Qty: 1.00

AN8C21A

Bolt

**

ll 1/10/20

Location

Loc Qty

Loc Code

ST

2

123966

2

st339

43

m127061

43

ST508

50

m127823

50

x2

D2741

Manufactured

No

250

Each

39.0000

1

1

D2741

Blade

**

ll 1/10/20

Location

Loc Qty

Loc Code

FG

11

100664

5

85480

1

98323

5

ST466

28

107206

28

x1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---	--

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D4168-041	350 SKIDTUBE ASSEMBLY, LH
	X			D4168-042	350 SKIDTUBE ASSEMBLY, RH
		X		D4168-043	350 SKIDTUBE ASSEMBLY, LH
			X	D4168-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
8	8	8	8	D3631-1	WASHER
7	7	7	7	D3873-1	BUSHING
1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
1				D4168-1	SKIDTUBE WELDMENT, LH
	1			D4168-2	SKIDTUBE WELDMENT, RH
		1		D4168-3	SKIDTUBE WELDMENT, LH
			1	D4168-4	SKIDTUBE WELDMENT, RH
4	4	4	4	D4170-1	SPACER
1	1	1	1	D4171-1	BUSHING
4	4	4	4	ALS4-1032-225	INSERT
4	4	4	4	AN3C6A	BOLT
1	1	1	1	AN3C34A	BOLT
4	4	4	4	AN3C36A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
9	9	9	9	AN960C10	WASHER (OR NAS1149CO363R)
4	4	4	4	AN960C10L	WASHER (OR NAS1149CO332R)
1	1	1	1	AN960C816L	WASHER (OR NAS1149CO832R)
5	5	5	5	MS21043-3	NUT
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

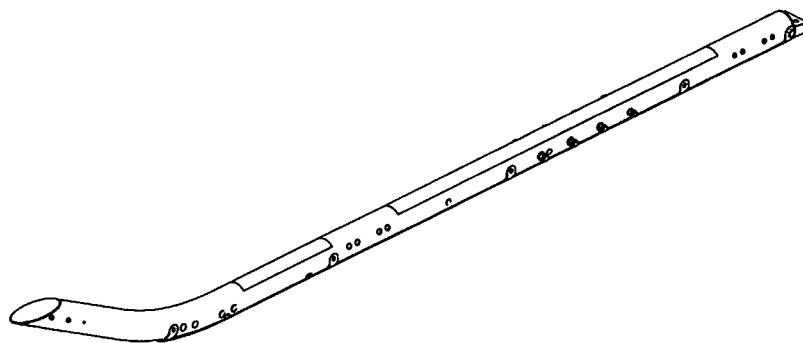
- 1) MATERIAL: MAKE D4168-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4168-041/-042/-043/-044 = 32.3 LBS
- 8) WELD PER DART QSI 004
- 9) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 10) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
FINISH WITH MEK DEGREASER.
- 11) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

111281
R214-01-9

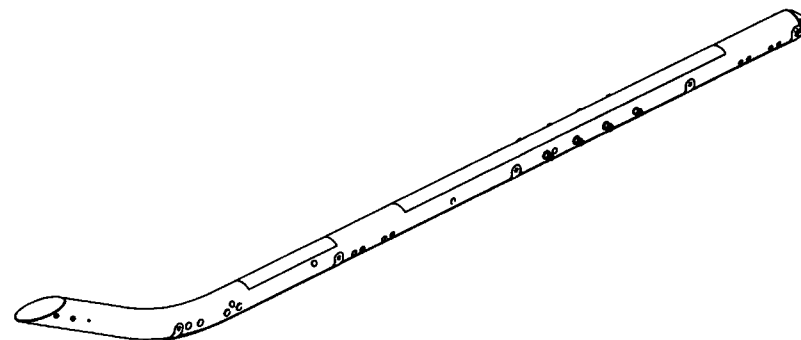
RELEASED
2013-08-13
JMP

B	ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
A	NEW ISSUE	SC	10.08.09
REV.	DESCRIPTION	BY	DATE
DESIGN	SC		
DRAWN	JP		
CHECKED	JP		
MFG. APPR.	JP		
APPROVED	JP		
DE APPR.	JP		
DATE	13.07.11		

DART AEROSPACE USA, INC. KENT, WA	
DRAWING NO. D4168	REV. B
TITLE 350 SKIDTUBE ASSEMBLY	SHEET 1 OF 11
	SCALE NTS
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D4168-041 350 SKIDTUBE ASSEMBLY, LH



D4168-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
2013-08-13
AW

DESIGN
DRAWN
CHECKED
MFG. APPR.
APPROVED
DE APPR.
DATE 13.07.11

SC
[Signature]

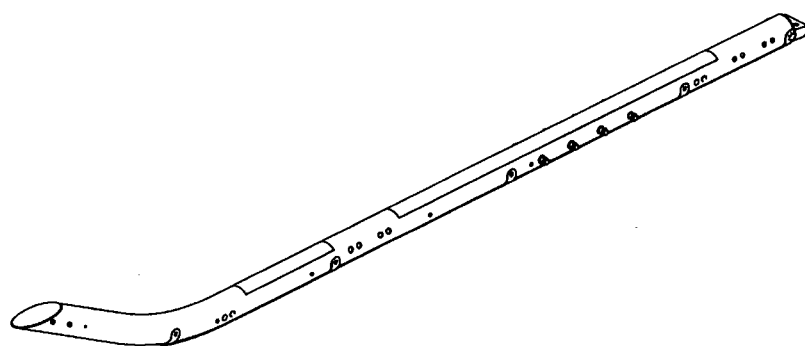
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KENT, WA

DRAWING NO.
D4168

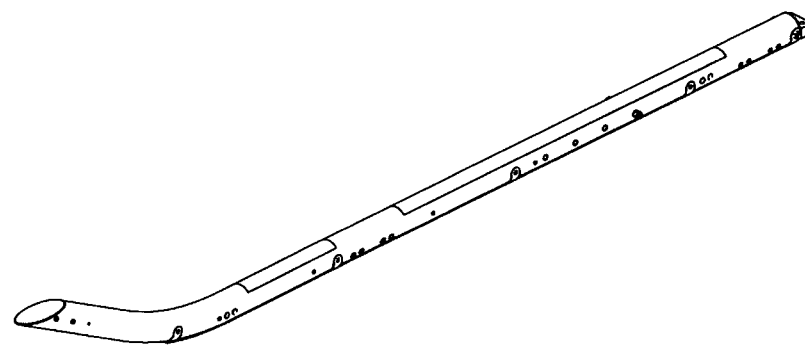
TITLE
350 SKIDTUBE ASSEMBLY

REV. B
SHEET 2 OF 11
SCALE
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D4168-043 350 SKIDTUBE ASSEMBLY, LH

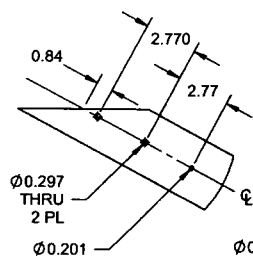
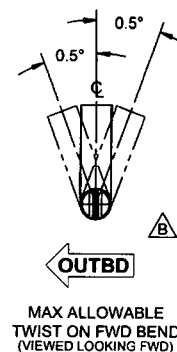


D4168-044 350 SKIDTUBE ASSEMBLY, RH

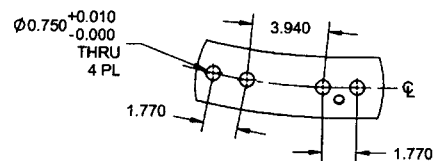
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2013-08-13
AND

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DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4168	SHEET 3 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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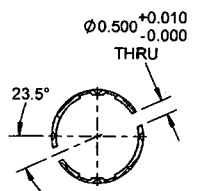
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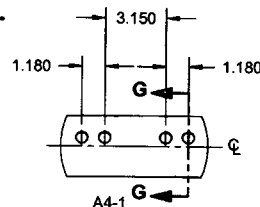
DETAIL A
SCALE 2X



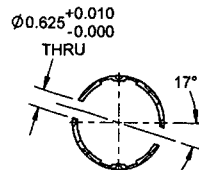
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SCALE 2X



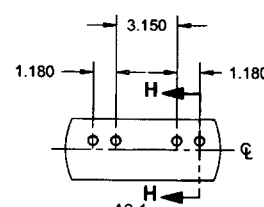
SECTION E-E
SCALE 3X, 2 PL



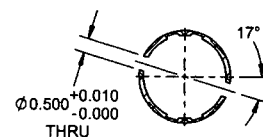
DETAIL C
SCALE 2X



SECTION G-G
SCALE 3X, 4 PL



DETAIL D
SCALE 2X



SECTION H-H
SCALE 3X, 4 PL

DESIGN
DRAWN
CHECKED
MFG. APPR.
APPROVED
DE APPR.
DATE

13.07.11

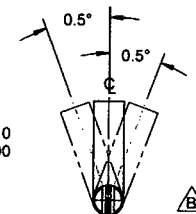
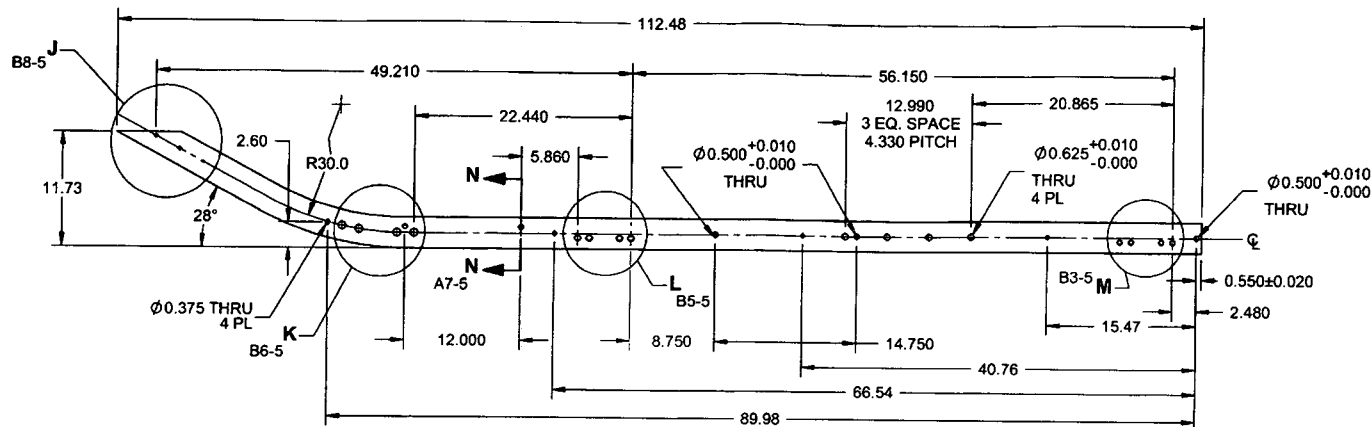
DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO.
D4168

TITLE
350 SKIDTUBE ASSEMBLY

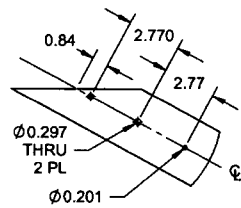
REV. A
SHEET 4 OF 11
SCALE
NTS

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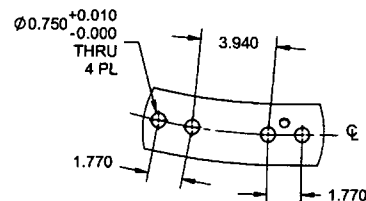


MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)

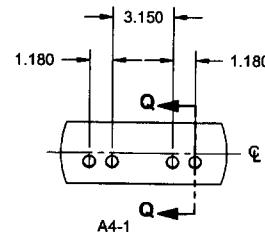
D4168-2 RH SKIDTUBE



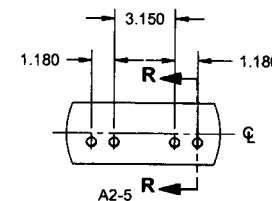
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SCALE 2X



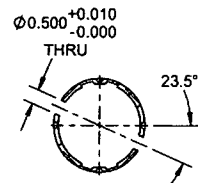
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SCALE 2X



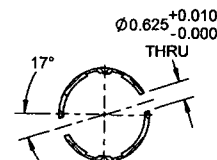
DETAIL L
SCALE 2X



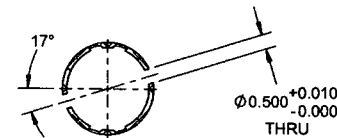
DETAIL M
SCALE 2X



SECTION N-N
SCALE 3X, 2 PL



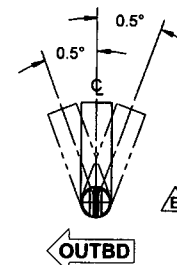
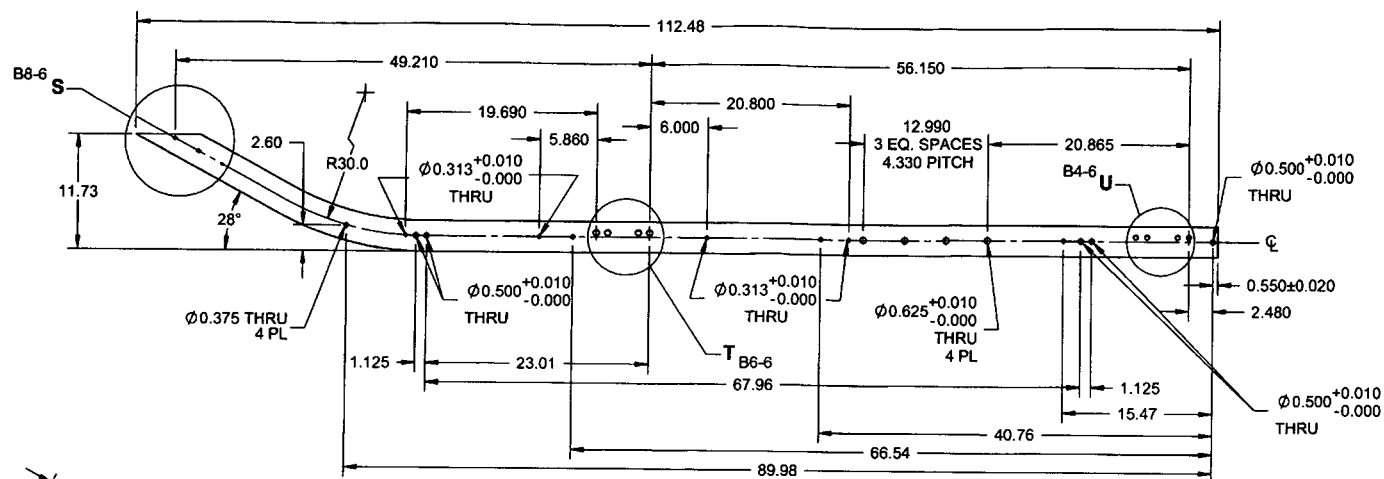
SECTION Q-Q
SCALE 3X, 4 PL



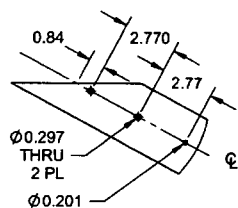
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SCALE 3X, 4 PL

RELEASED
2013-08-13

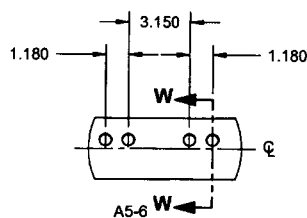
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CHECKED		SC		REV. B	
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APPROVED		SC		SCALE	
DE APPR.		SC		NTS	
DATE		13.07.11		TITLE	
				350 SKIDTUBE ASSEMBLY	
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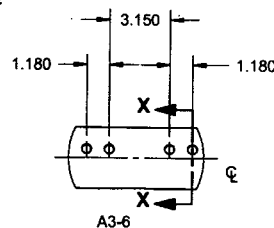
MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)



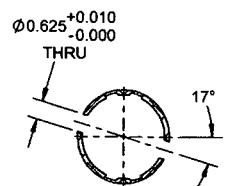
D8-6
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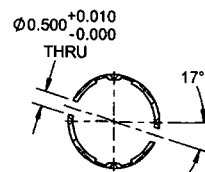
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DETAIL T
SCALE 2X



D3-6
DETAIL U
SCALE 2X



B6-6
SECTION W-W
SCALE 3X, 4 PL



B4-6
SECTION X-X
SCALE 3X, 4 PL

DESIGN
DRAWN
CHECKED
MFG. APPR.
APPROVED
DE APPR.
DATE

13.07.11

DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO.
D4168

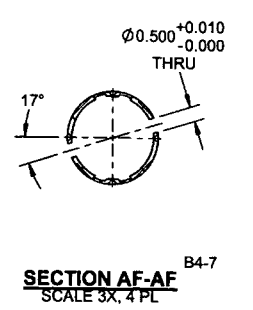
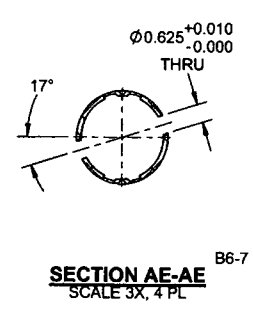
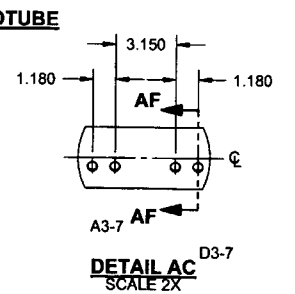
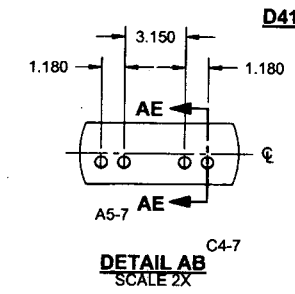
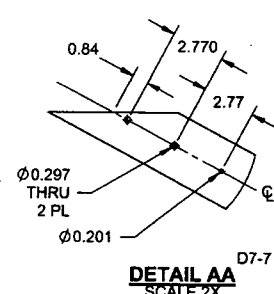
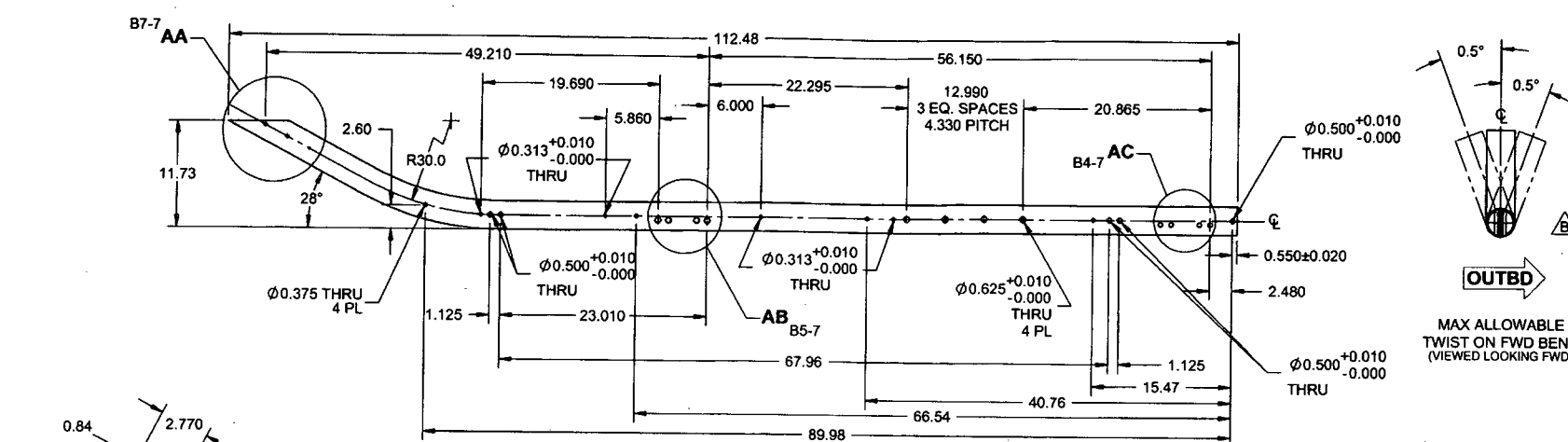
TITLE
350 SKIDTUBE ASSEMBLY

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REV. B
SHEET 6 OF 11
SCALE
NTS

RELEASED
2013-08-13

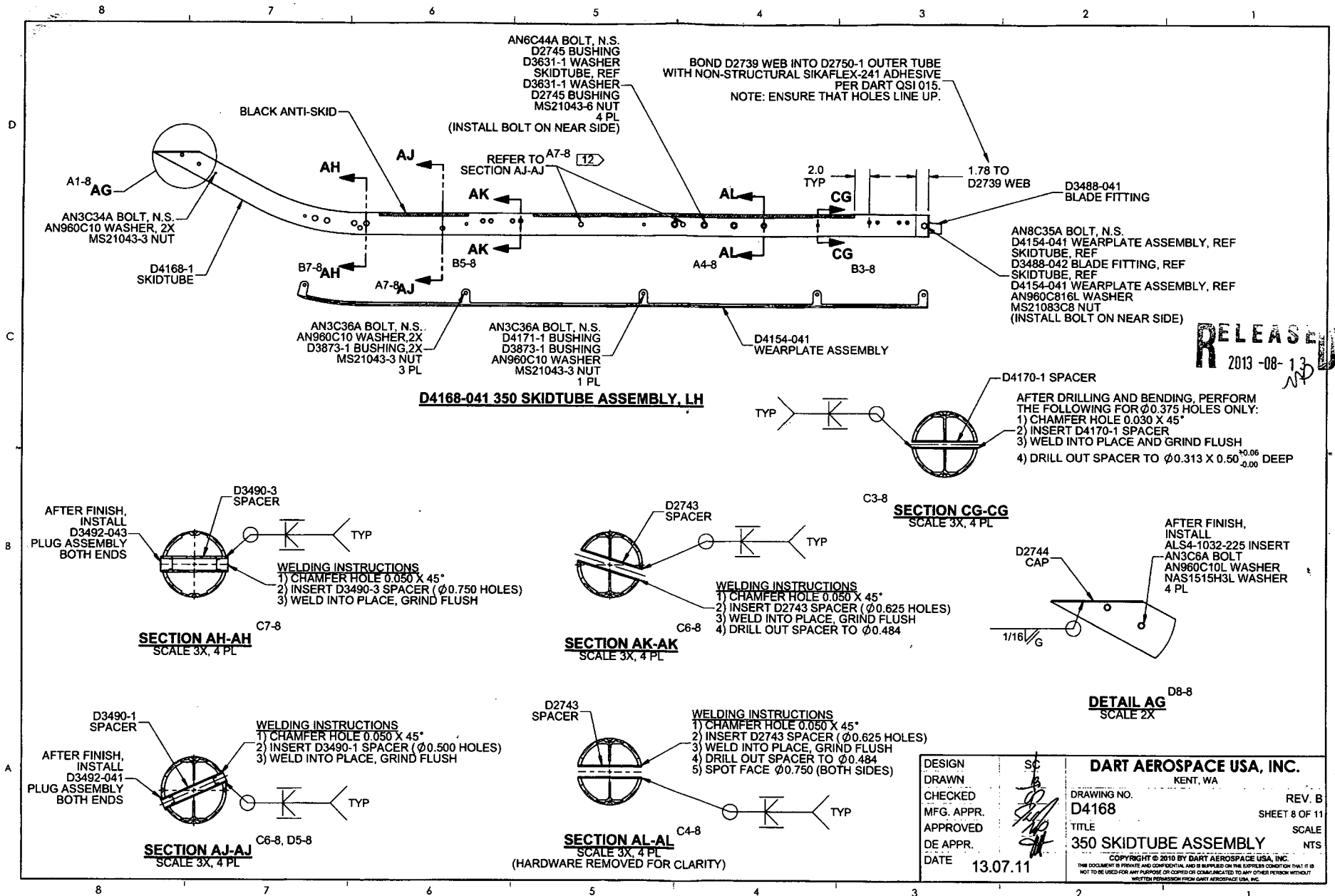
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RELEASED
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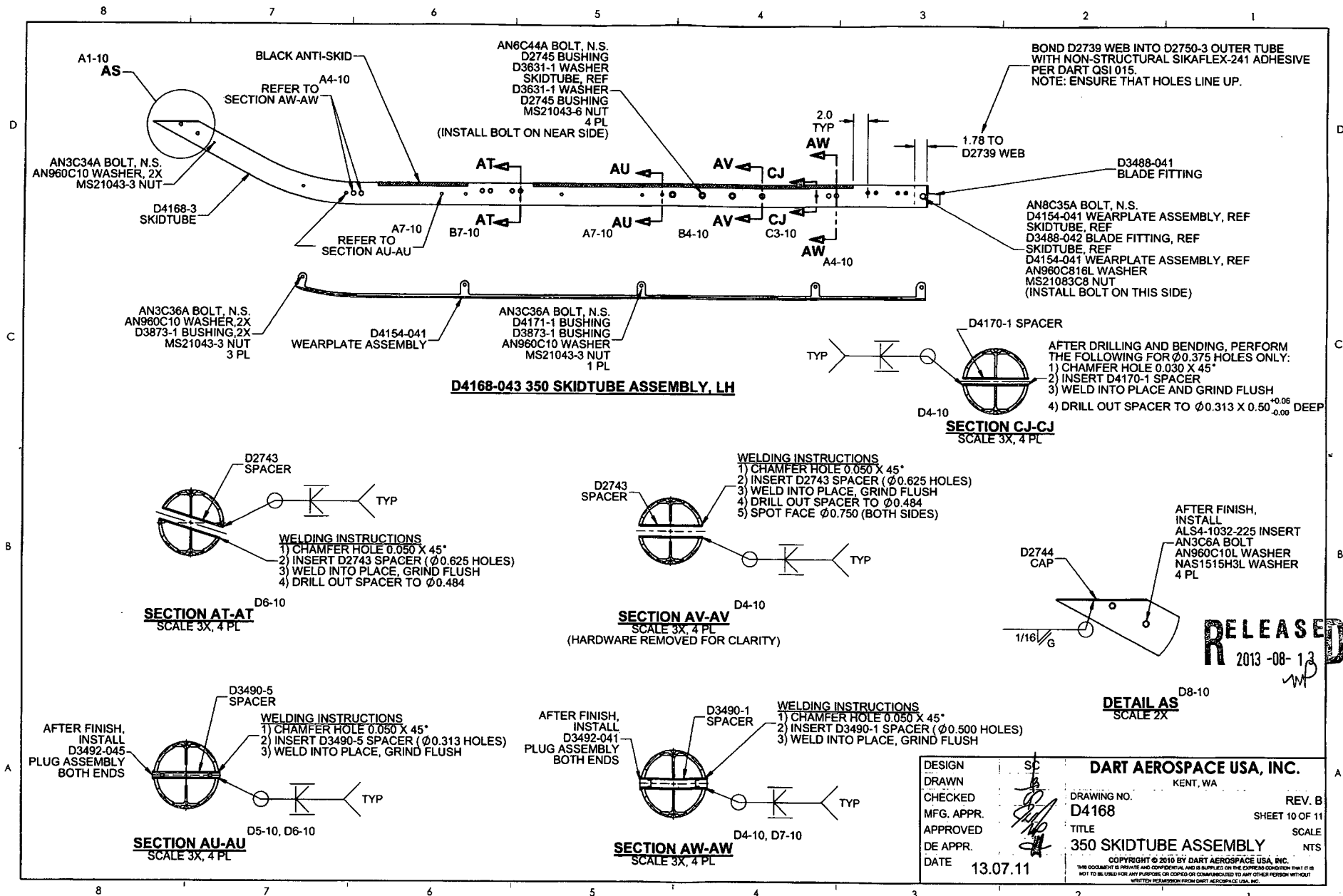
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED			
MFG. APPR.		DRAWING NO. D4168	REV. B
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY	SHEET 7 OF 11
DE APPR.			SCALE
DATE 13.07.11			NTS

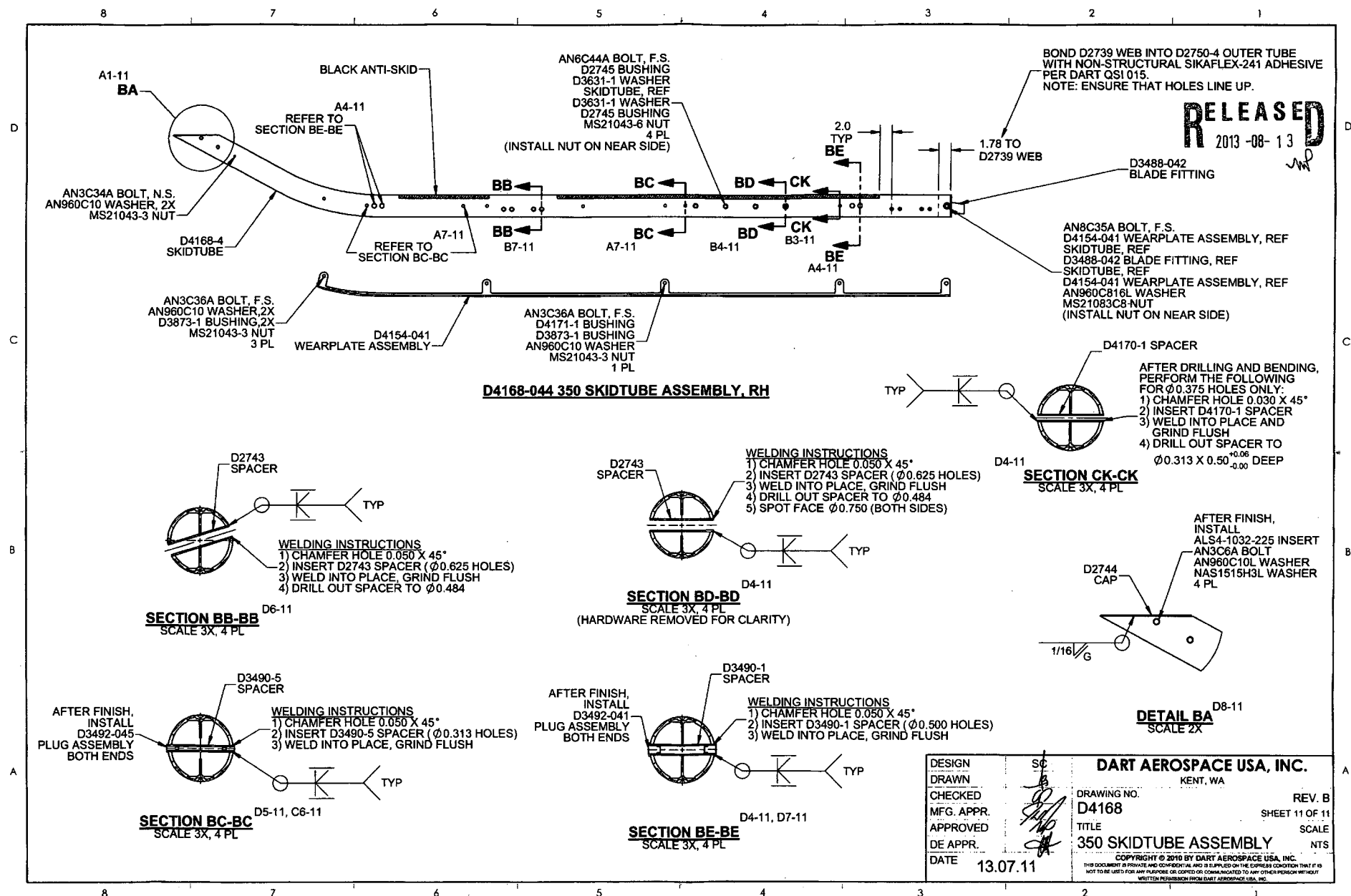
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ms







No. 337

**AWS D17.1/D17.1M:2010
SKIDTUBE WELDING TEST RECORD**

Name: Barclay Elliott
Job #: B109371
Part #: D350-636-012
Description: 350 skid tube
Welding Process: TIG ☒ MIG ☐
Base Material: Aluminum
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual:	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>
Penetration:	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>
Fusion:	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>
Cracks:	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>
Overlap (cold lap)	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>
Undercut:	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>
Pin holes:	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>
Porosity (surface):	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>
Coloration:	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>
Burn through:	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>

Qualifier: DAS
9
9-89 Date of Test Coupon: 13-12-03
Welder: Barclay Elliott Date of Test Coupon: 13-12-03

The above named individual is qualified to weld in accordance with AWS D17.1/D17.1M:2010.